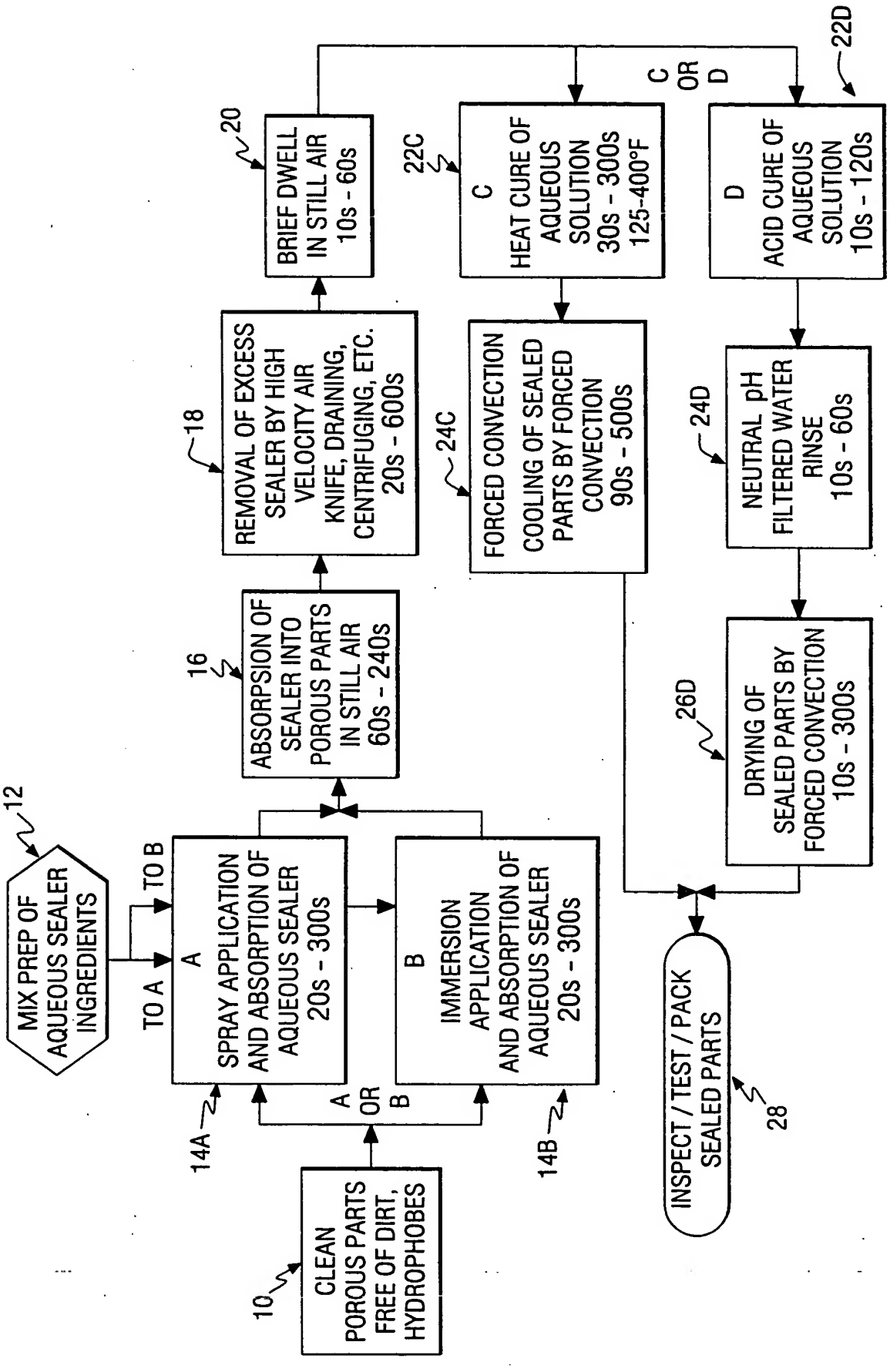
CLEAN POROUS PARTS FREE OF DIRT, HYDROPHOBES
10
A OR B
14A
14B
MIX PREP OF AQUEOUS SEALER INGREDIENTS
12
TO A
TO B
A SPRAY APPLICATION AND ABSORPTION OF AQUEOUS SEALER 20s - 300s
B IMMERSION APPLICATION AND ABSORPTION OF AQUEOUS SEALER 20s - 300s
ABSORPSION OF SEALER INTO POROUS PARTS IN STILL AIR 60s - 240s
16
REMOVAL OF EXCESS SEALER BY HIGH VELOCITY AIR KNIFE, DRAINING, CENTRIFUGING, ETC. 20s - 600s
18
BRIEF DWELL IN STILL AIR 10s - 60s
20
C OR D
C HEAT CURE OF AQUEOUS SOLUTION 30s - 300s 125-400°F
22C
D ACID CURE OF AQUEOUS SOLUTION 10s - 120s
22D
FORCED CONVECTION COOLING OF SEALED PARTS BY FORCED CONVECTION 90s - 500s
24C
NEUTRAL pH FILTERED WATER RINSE 10s - 60s
24D
DRYING OF SEALED PARTS BY FORCED CONVECTION 10s - 300s
26D
INSPECT / TEST / PACK SEALED PARTS
28